

Work Order ID 149074

Tuesday, July 19, 2016 2:43:27 PM

149074

Page 1

Item ID: D4634-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 7/5/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **JUL 20 2016** Tooling: _____ Date: _____
21
QC: **9-89** Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								

100

0.00

100

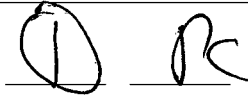
HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

**AUG 15 2016**

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Small Fab

Memo

0.16

***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-
WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET
DRY FOR ONE HOUR***
PLASTIC-WELD 2 BATCH: M1354B6

DAS
27
9-89

AUG 22 2016

1- Assemble as per Dwg D4634-041

2- install No Smoking & seat belt symbols

3- Install led lights

4- Install Air valves

5-Install Wiring Harness

5-Install wiring harness

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 16-08-23 PD

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>PPP</u>	0.00							
130									
Packaging	Memo	0.00				<u>IX</u>	DAS 28 9-89	AUG 23 2016	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

AUG 24 2016

dem 16/08/23

DQA: _____ Date: _____

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Picklist Print

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Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
 DL IPP REV E Dwg update 14/01/09
 DL IPP Rev F Dwg. update 14/02/03
 DL IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5 *D4652-5* Air Valve, 1.25 Id Disk Type		Manufactured	No			100	Each	0.0000	2	2			
D4743-1 *D4743-1* Speaker Grill		Manufactured	No			100	Each	20.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF005		20							
				129268		20							
MS21044-N08 *MS21044-N08* Nut		Purchased	No			100	Each	155.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		152							
				m131452		152							
				ST303		3							
				m127813		2							
				m130297		1							
MS24693-BB50 *MS24693-BB50* SCREW		Purchased	No			100	Each	160.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST288		160							
				m130207		160							

AUG 15 2016

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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, July 19, 2016 2:43:30 PM

Page 2

Work Order ID: 149074

149074

Parent Item: D4634-041

D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 7/5/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

100

Each

561.0000

8

8

NAS1149DN832.J

Washer

**

PC

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST264

477

M134180

477

D4634-141

Manufactured

No

100

Each

0.0000

1

1

D4634-141

Fwd, Center Ceiling Replacement Panel Assembly

**

B149139

DAS
27
9-89

D4646-1

Manufactured

No

100

Each

63.0000

2

2

D4646-1

Plenum Cap Assembly

**

PC

Location

Loc Qty

Loc Code

MF009

63

124234

13

125003

50

D4728-047

Manufactured

No

100

Each

23.0000

1

1

D4728-047

Advisory Light, Fwd

**

PC

Location

Loc Qty

Loc Code

MF003

6

117929

6

over001

17

124732

17

AUG 15 2016

Tuesday, July 19, 2016 2:43:31 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, July 19, 2016 2:43:31 PM

Page 3

Work Order ID: 149074

149074

Parent Item: D4634-041

D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 7/5/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4728-051

Manufactured No

100

Each

20.0000

1

1

D4728-051

Cabin Lights #1

**

PC

Location

Loc Qty

Loc Code

MF003

2

117932

2

over001

18

122713

18

PLT1.5M-M

Purchased

No

100

Each

2,855.000

7

7

PI T1 5M-M

Tie Wrap

**

PC

Location

Loc Qty

Loc Code

ST585

2855

m129712

2855

50-009-2

Purchased

No

100

Each

97.0000

1

1

50-009-2

Grommet

**

PC

Location

Loc Qty

Loc Code

ST562

97

m128047

47

m131501

50

2351-20-27-C3C

2351-20-27-
Z3CT

Purchased

No

100

Each

62.0000

1

1

2351-20-27-C3C

STUD

**

PC

Location

Loc Qty

Loc Code

ST569

62

m128068

19

m130318

43

AUG 15 2016

Tuesday, July 19, 2016 2:43:31 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

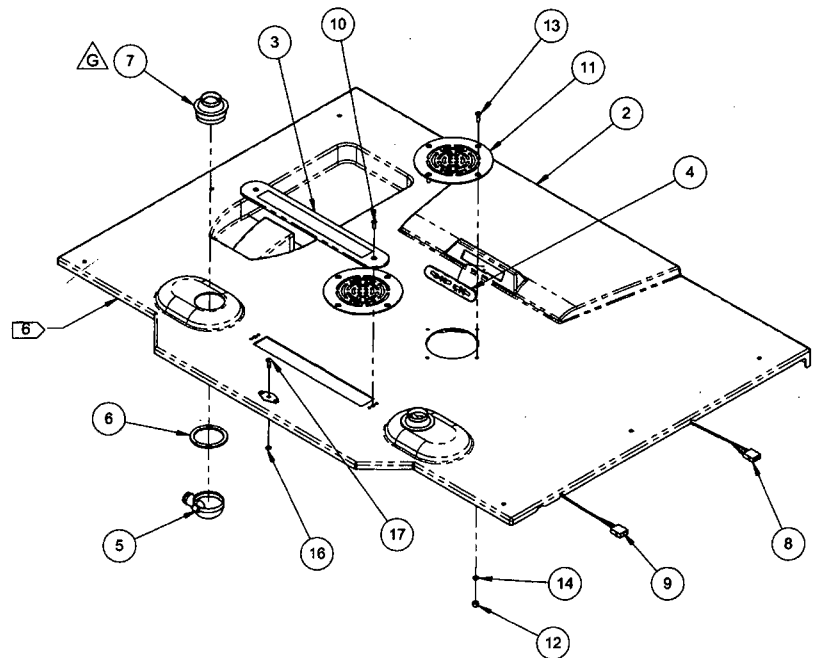


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QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																									



D4634-041 FWD, CENTER CEILING PANEL ASSY

ITEM NO.	QTY. -041	P/N	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
7	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4638-1)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT, SELF-LOCKING
13	8	MS24693-BB50	SCREW, CSK 100°
14	8	NAS1149DN832J	WASHER
15	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	DZUS STUD, OVAL HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149074 MJS
16-07-20

RELEASED

2015 JAN 26

ECN 14-634 4P

G	D4652-5 WAS D4652-1 (ZN D4-1, D4-3, D4-5); 10.28 WAS 10.20 (ZN B6-10, B5-12, B5-14); TIE-WRAP & MOUNTING PAD QTY CHANGE; MOUNTING PAD EDGE DISTANCE CHANGE	RF	14.11.28
F	REVISE BOM (ZN D4-7); ADD DIM (ZN B8-9); 10.20 WAS 10.05 (ZN B6-10, B5-12, B5-14); ADD DETAIL V (ZN C4-10, B4-12, C4-14, A4-16); CHANGE PROTRUDE SECTION DIMS TO REF (ZN C7-10, C7-12, C7-14)	RF	14.02.03
E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11 (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C6-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-16)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C6-6); D5021-1 (ZN D4-7, D5-7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-750S-9-C (ZN D4-9, B7-9); Ø0.129 (ZN B4-11, B4-13); DETAIL "U" (ZN C2-17); 3.83 WAS 3.87 (ZN C6-11); 2.00 WAS 2.02 (ZN D6-13); REVISE NOTE 8 & 10 (ZN A8-7, A8-8, A9-9); & NOTE 1 (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/-3/-5; Ø0.250 WAS Ø0.206 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-8); Ø0.206 WAS Ø0.207 (ZN D6-11, C3-13, C6-15) ADD DIM. (ZN B6-7, B7-7, D7-8, & D6-8)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS		
DATE	14.11.28		

APPROVED

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4634	REV. G
SHEET 1 OF 17	
TITLE CENTER CEILING PANELS	SCALE NTS
COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.0 lbs
- 8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

Linda Lacelle

From: Linda Lacelle
Sent: Monday, May 11, 2015 12:59 PM
To: Nigel Forbes
Subject: FW: 139 Ceilings Deviation

All Mike G...

From: David Shepherd
Sent: May-11-15 12:58 PM
To: Nigel Forbes; Bill Beckett
Cc: Roberto Fuentes; Linda Lacelle; Mario Poulin; Daryl Leger; Harvey Siemens
Subject: RE: 139 Ceilings Deviation

Nigel/Bill,

Can you clarify what is going on here. About 6 months ago, Operations pushed Engineering to change the lights and air vents previous lights and air vents were waaaaaaay too expensive. Now we have 3 years supply of the old expensive parts. I'm con

Regards,
David

From: Mario Poulin
Sent: May-11-15 10:53 AM
To: Daryl Leger; Harvey Siemens
Cc: Roberto Fuentes; David Shepherd; Linda Lacelle
Subject: RE: 139 Ceilings Deviation

No orders pending,

From: Daryl Leger
Sent: Monday, May 11, 2015 12:49 PM
To: Mario Poulin; Harvey Siemens
Cc: Roberto Fuentes; David Shepherd; Linda Lacelle
Subject: RE: 139 Ceilings Deviation

Harvey
Re: 139 Ceilings

We have old stock quantities of	D4652-1 air Valve	QTY 163. (enough old stock for 13 sets)	New Stock Qty. 0
Old stock quantity of	D4638-1 light	QTY 73. (enough old stock for 24 sets)	New Stock Qty. 0

We do not have any orders on hand for ceilings and I have no idea if there are any pending orders.
Please advise

Daryl

From: Mario Poulin
Sent: Monday, May 11, 2015 10:45 AM
To: Harvey Siemens; Daryl Leger

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Cc: Roberto Fuentes; David Shepherd; Linda Lacelle

Subject: RE: 139 Ceilings Deviation

Harvey,

We have stock for about 3 years, Ok to keep some old ones in case, but we should be reducing inventory first.

Mario,

From: Harvey Siemens

Sent: Monday, May 11, 2015 10:18 AM

To: Daryl Leger

Cc: Roberto Fuentes; Mario Poulin; David Shepherd

Subject: RE: 139 Ceilings Deviation

Daryl,

I thought we were going to move to the new parts and not use up all the old stock in case somebody wanted/needed replace

Just a little curious, why we are going backwards??

HS

From: Daryl Leger

Sent: May-11-15 5:56 AM

To: Harvey Siemens

Cc: Roberto Fuentes; Mario Poulin

Subject: 139 Ceilings Deviation

Harvey

Can you please provide a standard email that we can use to make D4634-xxx panels at Rev. F until old stock parts are used up

We will also need same type document to produce D4635-xxx panels as per Rev. E until old stock parts are used up.

We will not use unmatched parts (old/new on same set panel) as old stock diminishes.

Daryl

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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